



Dart Aerospace Ltd.

1270 Aberdeen St

Hawkesbury, ON

K6A 1K7

Canada

Tel (613) 632-5200

Fax 613 632-5246

RBW6500G03531-3G

Job Sheet 198987



Part No: RBW6500G03531-3G

Job Qty: 2 pcs

Part Name: Bearing Outer Race Installation Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/8/19

Job Tracking No:

Due Date: 10/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6500G03531-3G Rev A IPP Rev. A 19.08.06 New issue DP Verify DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.

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CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Container No: S233425



Part: RBW6500G03531-3G

Job No: 198987

Serial No/Batch: S233425

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 11/20/19

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	10/22/19		0.00	0.40	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	2 pcs	10/22/19		0.00	0.00	QC 5 - 10		NOV 21 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
120	Packaging 3-1 - Stock - B4B	2 pcs	10/22/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - FG	2 pcs	10/22/19		0.00	0.00	QC 21 - FG - 21	DAS 21 1-89	NOV 25 2019 6A143F
							QC 21 - FG - 70		
							QC 21 - SA - 53		

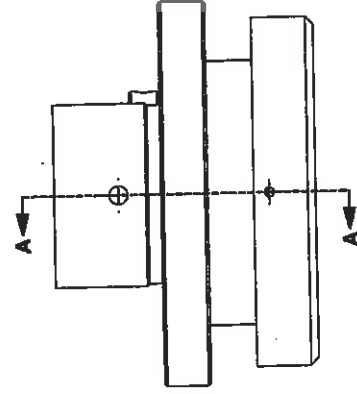
Part Op 100 - Assemble as per DWG. See note 7 and 8.
Descriptions: 110 - QC5- Inspect part completeness to step on W/O
120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
130 - QC21- Final Inspection - Work Order Release

64
5+350
6A018
TBD
138A
107

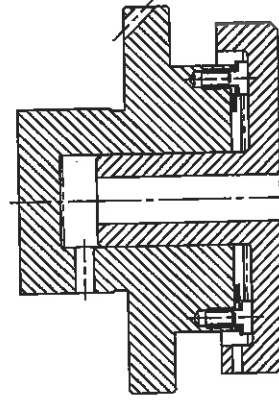
013019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	4 Ea (2 ea)	100-Small Fab - 1	\$199293
90905A655	316 SS Split Ring 15/16" ID. X 1-1/16" OD. X 1/8" Thick	4 Ea (2 ea)	100-Small Fab - 1	\$206433
AN3C3A	Bolt	4 Ea (2 ea)	100-Small Fab - 1	\$232686
CL-2-C	Lanyard Wire	1,2500 ft (.625 ea)	100-Small Fab - 1	\$192012
NAS1149C0332R	Washer (AN960C10L)	4 Ea (2 ea)	100-Small Fab - 1	FM136444-15
RBW6500G03531-3G-1	Press Assembly	2 pcs (1 ea)	100-Small Fab - 1	\$231651
RBW6500G03531-3G-3	Base	2 pcs (1 ea)	100-Small Fab - 1	\$222725
RBW6500G03531-3G-4	Flange Support	4 pcs (2 ea)	100-Small Fab - 1	\$209879
RBW6500G03531-3G-5	Centering Pin	2 pcs (1 ea)	100-Small Fab - 1	\$217455
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3896T31	4	704	0
	90905A655	4	16	0
	AN3C3A	4	302	0
	CL-2-C	1	1,168	0
	NAS1149C0332R	4	3,203	0
	RBW6500G03531-3G-1	2	0	0
	RBW6500G03531-3G-3	2	0	0
	RBW6500G03531-3G-4	4	0	0
	RBW6500G03531-3G-5	2	0	0
Part Specifications				
Specifications could not be found.				

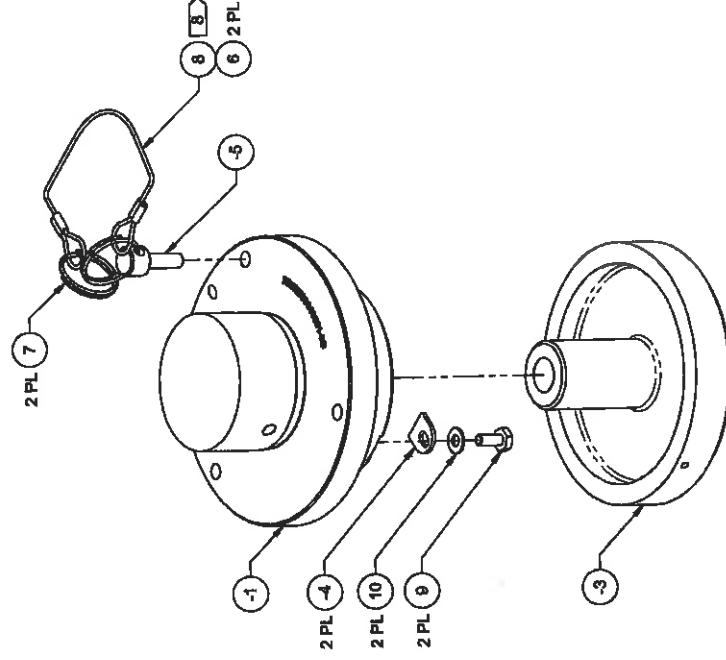
ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6500G03531-3G-1	PRESS ASSEMBLY
-3	1	RBW6500G03531-3G-3	BASE
-4	2	RBW6500G03531-3G-4	FLANGE SUPPORT
-5	1	RBW6500G03531-3G-5	CENTERING PIN
6	2	McMaster#3886T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
7	2	McMaster#80905A655 OR EQUIV.	316 SS SPLIT RING 1 1/16" ID. X 1-1/16" OD. X 1/8" THK.
8	1	CARR-LANES#OL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.
9	2	AN3CSA	BOLT
10	2	NAS1148C032R	WASHER



ITEMS 6, 7, AND 8
REMOVED FOR CLARITY



SECTION A-A



RBW6500G03531-3G BEARING OUTER RACE INTSL. TOOL

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 198987 MJS
1908-89

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN

8) ASSEMBLED LANYARD LENGTH MUST BE 7'-4-1/2". LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM -5
9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A		NEW ISSUE	DESCRIPTION	ECN #	KPT	BY
REV.	DESIGN	DRAWN	CHECKED	MFG. APPR.	APPROVED	DATE
1	1	1	1	1	1	2019-07-02
DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA		REV. A		
TOOL PART #		RBW6500G03531-3G		SHEET 1 OF 8		
TITLE		BEARING OUTER RACE INTSL. TOOL		SCALE NTS		
DATE		2019-07-02		NTS		

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Completed By		Lead hand / Supervisor			
		QC / QA Coordinator			